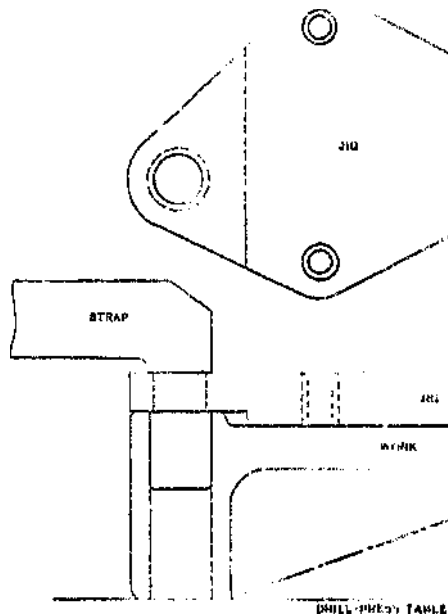


to insure getting the proper amount of metal around the hole *D*. At the bottom it is located against the sliding point /i, the latter being adjustable, because the location of the work, is determined by the other locating points and surfaces. The work is held against the locating points by the long set-screw shown to the left. This clamping arrangement, however, is not to be recommended, because this screw must be screwed back a considerable distance in order to permit insertion and removal of the work.



a  
 <\*<H'      \* \$

**Fig. 17. Simple Plate Jig for Drilling** Bracfeft shown in Fig. 15,

after Hole B has been Bored in the Lathe

An eye-bolt used in the manner described in a preceding chapter would have given better service. The three straps 6\* hold the work against the bottom surface, and the two straps // hold it against the finished surface at *B*. There *h* not a long finished hole through the casting, as would be assumed from its appearance, but simply a short bearing at each end, the remaining part of the hole being cored out. For this reason, the hole is drilled and reamed instead of being bored out, as the latter operation